

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013121**Date Inspected:** 14-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang and Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 7DE

This QA Inspector performed Inspection along with Caltrans QA Mr. Manikandan for the following Segment 7DE from Panel Point 56, PP 57 and PP 58 for the following items.

Floor Beam Flatness measurement performed the recorded measurements submitted to lead as well to the engineer for further action.

Segment 7EE

This QA Inspector performed Inspection along with Caltrans QA Mr. Manikandan for the following Segment 7EE from Panel Point (PP) 59 and PP 60 for the following items.

Floor Beam Flatness measurement performed the recorded measurements submitted to lead as well to the engineer

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for further action.

### Segment 7BE

This QA Inspector performed Inspection along with Caltrans QA Mr. Manikandan for the following Segment 7BE from Panel Point (PP) 52 for the following items.

Deck Panel Diaphragm to Deck Panel Plumbness and Flatness measurement performed the recorded measurements submitted to lead as well to the engineer for further action.

### Segment 7CE

This QA Inspector performed Inspection along with Caltrans QA Mr. Manikandan for the following Segment 7BE from Panel Point (PP) 55 for the following items.

Deck Panel Diaphragm to Deck Panel Plumbness and Flatness measurement performed the recorded measurements submitted to lead as well to the engineer for further action.

### Segment 7DE

This QA Inspector performed Inspection along with Caltrans QA Mr. Manikandan for the following Segment 7BE from Panel Point (PP) 58 for the following items.

Deck Panel Diaphragm to Deck Panel Plumbness and Flatness measurement performed the recorded measurements submitted to lead as well to the engineer for further action.

### Segment 7DW

The QA inspector performed inspection for the punch list item 987 for T-Rib web dimension at PP 58 for Segment 7DW as Floor Beam FL3 stiffeners for Base material repair for two horizontal stiffener located at FL3 Floor Beam at PP 58 Cross Beam side and the dimension verification performed, found the dimension meeting the requirements.

### Segment 7BE

The QA inspector prepared Punch List for the skin flatness for Bottom Panel between PP 50 to 50.5 and observed 23mm forwarded the punch list to lead as well to the engineer for review and further action. Please refer the pictures attached for more comprehensive details.

### Segment 7BE

The QA inspector prepared Punch List for the Longitudinal Diaphragm (LD) web deformation between PP 50 to 50.5 and observed 50mm forwarded the punch list to lead as well to the engineer for review and further action. Please refer the pictures attached for more comprehensive details.

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## Segment 7DE

This QA Inspector observed ZPMC welding personnel performing welding for weld joint SSD27-PP057-171. Welder is identified as 222396. PMCK identified as Partial Height Diaphragm at FL3 location. In process Flux Cored Arc Welding (FCAW) appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-B-T-2232-T.

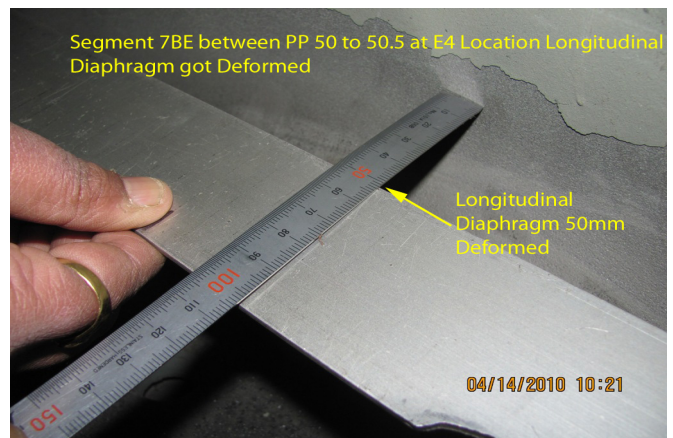
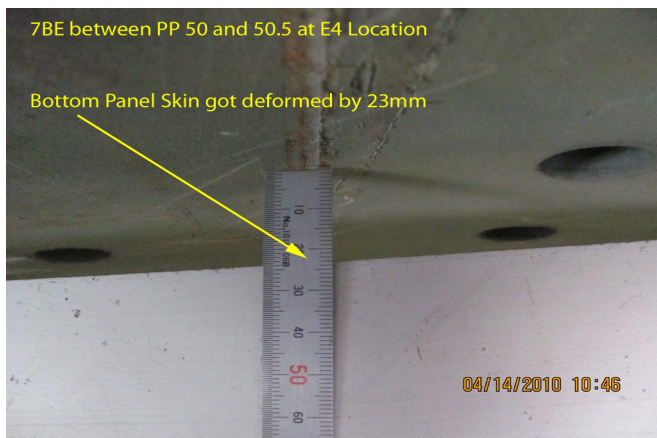
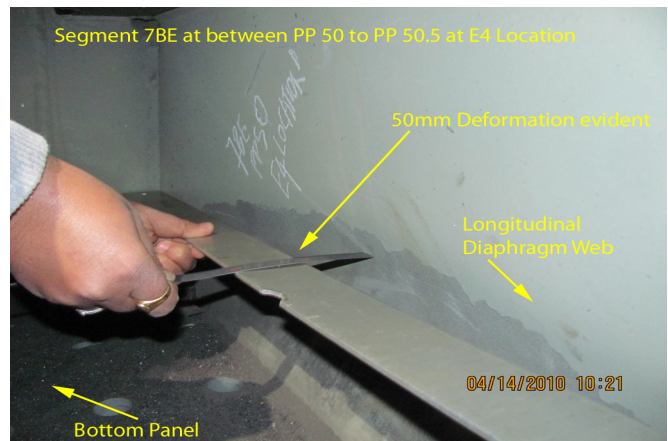
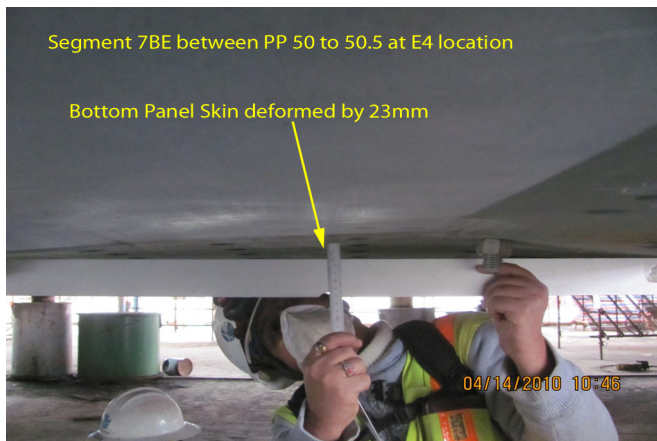
## Segment 7DE

This QA Inspector observed ZPMC welding personnel performing welding for weld joint SSD27-PP057-118. Welder is identified as 220068. PMCK identified as Partial Height Diaphragm at FL3 location In process Flux Cored Arc Welding (FCAW) appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-B-T-2233-T.

## Segment 7DE

This QA Inspector observed ZPMC welding personnel performing welding for weld joint SSD27-PP057-138. Welder is identified as 220067. PMCK identified as Partial Height Diaphragm at FL3 location In process Flux Cored Arc Welding (FCAW) appears to be progressing in compliance with Caltrans Engineer Approved welding procedure WPS-B-T-2233-T.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Miller,Mark
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QA Reviewer
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